

Split

Work Order ID 102091 -1

102091

Page 1

Item ID: D3179-041

Accept

N900040100

Setup Start

NS1

Revision ID: ~~100~~ n/a

Item Name: Fwd Litter Tie Down

Stop

NS2

Start Date: 5/30/2013

Start Qty: ~~8.00~~ 2

8

Cust Item ID:

Required Date: 5/30/2013

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 13-5-23

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3179

Rev D

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 12.150" long

PD 13/05/29

8 13 05 30

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA297 Rev: AA & Dwg D3179-1 Rev: 0 2-
Deburr per dwg D3179-1

PD 13/06/01

D40
02
88

8 1

13-05-31

(Pto)

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

D40
02
88

8 1

13-05-31

DQA:

Date: 13/08/22



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 13/08/21

Work Order update only ☐

| | | | | | |
|--------------------|---|---|------------------------------------|--|--------------------------------------|
| Work Order: 102091 | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS | | | |
| Part No. D3179-041 | | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> |
| NCR No. 13-2962 | | Machining <input checked="" type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> |
| | | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> |
| | | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|----------|------|-----|---|-------------------|------------------------------------|---------------|--------------|--------------|
| Design | 13/05/31 | 110 | x1 | program was supposed to use 1/2" endmill to make pocket instead used 3/4 endmill pocket dims are 250" wider + higher than nominal | GP | Acceptable Not high stress area | GP 13/5/31 | S 13/5/31 | 13/5/31 |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | | |
|--|--|---|--|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|--|

Work Order ID 102091***102091***

Page 2

Item ID: D3179-041

Accept

N900040100Setup Start ***NS1***

Revision ID: U/R

Item Name: Fwd Litter Tie Down

Stop ***NS2***

Start Date: 5/30/2013 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/30/2013 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

13-6-3

8

DAS
04
2-83

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

8 NG13 & 5

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

8x 8 m.f 13/06/05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | |
|---|---|--|---|--|---|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:33%;"> Skid-tube <input type="checkbox"/> Machining <input checked="" type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width:33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width:33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width:33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table> | Skid-tube <input type="checkbox"/> Machining <input checked="" type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> |
| Skid-tube <input type="checkbox"/> Machining <input checked="" type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|----------|------|-----|--|-------------------|--------------------|------------------------|--------------|--------------|
| Design | 13053110 | x1 | 1 | up right portion of tie down .015" off centre R.L. operator Error | MA | ACCEPTABLE AS IS | MA 13.05.31 | 13/06/03 | 13/06/03 |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator <input checked="" type="checkbox"/> | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | | |
|--|--|---|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input checked="" type="checkbox"/> Other <u>origin</u> | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled |
|--|--|---|---|--|

Work Order ID 102091

102091

Page 3

Item ID: D3179-041
Revision ID: U/R
Item Name: Fwd Litter Tie Down
Start Date: 5/30/2013 Start Qty: 8.00
Required Date: 5/30/2013 Req'd Qty: 8.00
Reference:

Accept

N9000040100

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

160

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

8x4 m/f 13/06/06

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

8x4 Ill w/06/06

180

Small Fab

0.00

180

Small Fab

Small Fab

Memo

Assemble as per Dwg D3179

0.00

2 0 FF 13-08-15

NOTE: ACCEPTABLE TO
OPEN UP Ø 0.242" HOLES

TO Ø 0.248"-0.250"

FOR INSTALLATION OF D2372

PINS.

QSI 042

13.06.06

DQA:

Date: 13/08/22



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 13/08/21

Work Order update only ☐

| | | | | | |
|--------------------|---|---|------------------------------------|--|--------------------------------------|
| Work Order: 102091 | DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS | | | |
| Part No. D3179-041 | | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> |
| NCR No. 13-29103 | | Machining <input checked="" type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> |
| | | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> |
| | | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|---------|------|-----|--|-----------------------|---|------------------------|-----------------------|--------------|
| Design | 1305-31 | 110 | x1 | re taking Y origin on 3rd op, tool holder with edge finder hit part and took .100" gauge out of bottom of part R.L. LOA operator credit pay check to Jop | 052012 1306/03 | scrap + replace RT M 81421 <div style="border: 1px solid black; border-radius: 50%; padding: 10px; display: inline-block;">\$322.09</div> | 1305-31 1306/03 | 052012 1306/03 | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator <input checked="" type="checkbox"/> | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | | |
|---|---|--|---|
| <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Folio/Program | <input type="checkbox"/> Outside Dimensions |
| <input type="checkbox"/> Centre Not Concentric | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Grain | <input type="checkbox"/> Over/Under tolerance |
| <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damage/Defect | <input type="checkbox"/> Hardware | <input type="checkbox"/> Part Incorrect |
| <input type="checkbox"/> Crimp/Kink/Ripple/Wave | <input type="checkbox"/> Burrs | <input type="checkbox"/> Inspection Incomplete/Unqualified | <input type="checkbox"/> Part Lost/Missing |
| <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Instructions Incomplete/Unclear | <input type="checkbox"/> Part Moved |
| <input type="checkbox"/> Crushing | <input type="checkbox"/> Countersink | <input type="checkbox"/> Misaligned/off center | <input type="checkbox"/> Positioned Wrong |
| <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Mislabeled | <input type="checkbox"/> Power Loss/Surge |
| <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Drawing | <input type="checkbox"/> Misread | <input type="checkbox"/> Pressure/Forced |
| <input type="checkbox"/> Marks/Chatter | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Off-set | <input type="checkbox"/> Set-up |
| <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Calibration | <input type="checkbox"/> Temperature/Cure |
| <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Weld |
| | | | <input type="checkbox"/> Wrong Stock Pulled |
| | | | <input type="checkbox"/> Other |

Work Order ID 102091

Thursday, May 23, 2013 3:29:44 PM

102091

Page 4

Item ID: D3179-041 Accept *N9000040100* Setup Start *NS1*
Revision ID: U/R Stop *NS2*
Item Name: Fwd Litter Tie Down
Start Date: 5/30/2013 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 5/30/2013 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hour | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|---------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------------|
| 190 *190* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | 2 | | | |
| 200 *200* Packaging Packaging | Identify as per dwg & Stock Location: <i>ST221</i> Memo | 0.00 0.00 | | | | 2x | | | <i>11.12.13-08-15</i> |
| 210 *210* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | <i>13/8/20</i> |

13.8.16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|--|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence |
|--|--|---|

| | |
|--|--|
| <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|

Picklist Print

Thursday, May 23, 2013 3:29:42 PM

Page 1

Work Order ID: 102091
Parent Item: D3179-041
Parent Item Name: Fwd Litter Tie Down

Start Date: 5/30/2013
Start Qty: 8.00

Required Date: 5/30/2013
Required Qty: 8.00

Comments: IPP A1 03.01.09 Added Acid etch end alodine RF
IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP Rev:C 08-12-10 add part list DD verified by:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| NAS1149D0332J Washer | | Purchased | No | | | 100 | Each | 798.0000 | 3 | 24 | FF | 13-08-15 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST293 | | 360 | | | | | | | |
| | | | | 125268 | | 360 | | | | 24 6 | | | |
| | | | | ST294 | | 438 | | | | | | | |
| | | | | 122973 | | 68 | | | | | | | |
| | | | | 125044 | | 370 | | | | | | | |
| D2372 Quick Release | | Manufactured | No | | | 180 | Each | 31.0000 | 2 | 16 | FF | 13-08-15 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | GA | | 31 | | | | 4 | | | |
| | | | | 101076 | | 12 | | | | | | | |
| | | | | 86001 | | 2 | | | | | | | |
| | | | | 97848 | | 5 | | | | | | | |
| | | | | 99810 | | 12 | | | | | | | |
| D2444 Pip Pin Assembly | | Manufactured | No | | | 180 | Each | 25.0000 | 1 | 8 | FF | 13-08-15 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST010 | | 25 | | | | | | | |
| | | | | 101027 | | 10 | | | | | | | |
| | | | | 97238 | | 1 | | | | * | | | |
| | | | | 98455 | | 5 | | | | | | | |
| | | | | 99370 | | 4 | | | | 2 | | | |
| | | | | 99784 | | 5 | | | | * | | | |

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
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|--|--|---|--|

Picklist Print

Thursday, May 23, 2013 3:29:43 PM

Page 2

Work Order ID: 102091
Parent Item: D3179-041
Parent Item Name: Fwd Litter Tie Down

Start Date: 5/30/2013 Required Date: 5/30/2013
Start Qty: 8.00 Required Qty: 8.00

D6201 Manufactured No
"T" Extrusion

180 f 47.9646 1.0125 8.5263158

PA 13/05/29

Location Loc Qty Loc Code

MAT028 47.96463153
81421 4.61863153
83987 20
89645 3.346
96808 20

x 4.05

3.1
1.1

END OF BATCH
END OF BATCH

MS21042L3 Purchased No
Nut

180 Each 3,403.0000

1 8

FF 13-08-15

Location Loc Qty Loc Code

FP001 3
122141 3
GA 18
122452 18
ST314 268
117885 32
119017 55
119075 138
123265 43
ST506 3114
123900 954
124291 2160

MS27039-1-13 Purchased No
Screw

180 Each 944.0000

1 8

FF 13-08-15

Location Loc Qty Loc Code

GA 2
119736 2
ST304 42
119736 42
ST306 400
125654 400
ST506 500
124326 500

2 2

Thursday, May 23, 2013 3:29:43 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
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| Material | | | | | | | | | |
| Operator | | | | | | | | | |
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| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

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|--|--|---|--|

D2444 PIP PIN

MS27039-1-13 SCREW
NAS1149D0332J WASHER 3PL
MS21042L3 NUT

FWD BRACKET
OUTBD

D2372 QUICK
RELEASE
2 PL

D3179-1 LITTER TIE DOWN BRACKET

D3179-041 LITTER TIE DOWN BRACKET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3179-041" ON BOTTOM FACE USING FINE POINT PERMANENT INK MARKER AS PER QSI 044 METHOD 6.1
- 7) WEIGHT: 2.79 lbs

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|---------------|-------------------------|
| | X | D3179-041 | LITTER TIE DOWN BRACKET |
| 1 | 2 | D2372 | QUICK RELEASE |
| 2 | 1 | D2444 | PIP PIN |
| 3 | 1 | D3179-1 | LITTER TIE DOWN BRACKET |
| 4 | 1 | MS21042L3 | NUT |
| 5 | 1 | MS27039-1-13 | SCREW |
| 6 | 3 | NAS1149D0332J | WASHER (AN960JD10L) |

RELEASED
2013-05-16

| | | | |
|------------|--|---|--------------|
| D | POSITION AND SHAPE OF LITTER CAPTURE SLOTS CHANGED (ZN B4-2, B5-2, C7-2). ADD ENGRAVING NOTE (ZN C4-2). REF CIR13-15 | DB | 13.03.22 |
| C | ADD D3179-041 & PARTS LIST (ZN B8-1, D2-1); D3179-1 WAS D3179 (ZN A5-2); REMOVE ENGRAVE P/N | RF | 08.11.07 |
| B | REFORMAT DRAWING, FINISH WAS ANODIZE | DC | 07.06.06 |
| A | NEW ISSUE | RF | 02.12.09 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3179 TITLE LITTER TIE DOWN BRACKET COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DRAWN | DB | | |
| CHECKED | A.P. | | |
| MFG. APPR. | 21 | | |
| APPROVED | 21 | | |
| DE APPR. | 21 | | |
| DATE | 13.03.22 | REV. D | SHEET 1 OF 2 |
| | | SCALE | NTS |

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

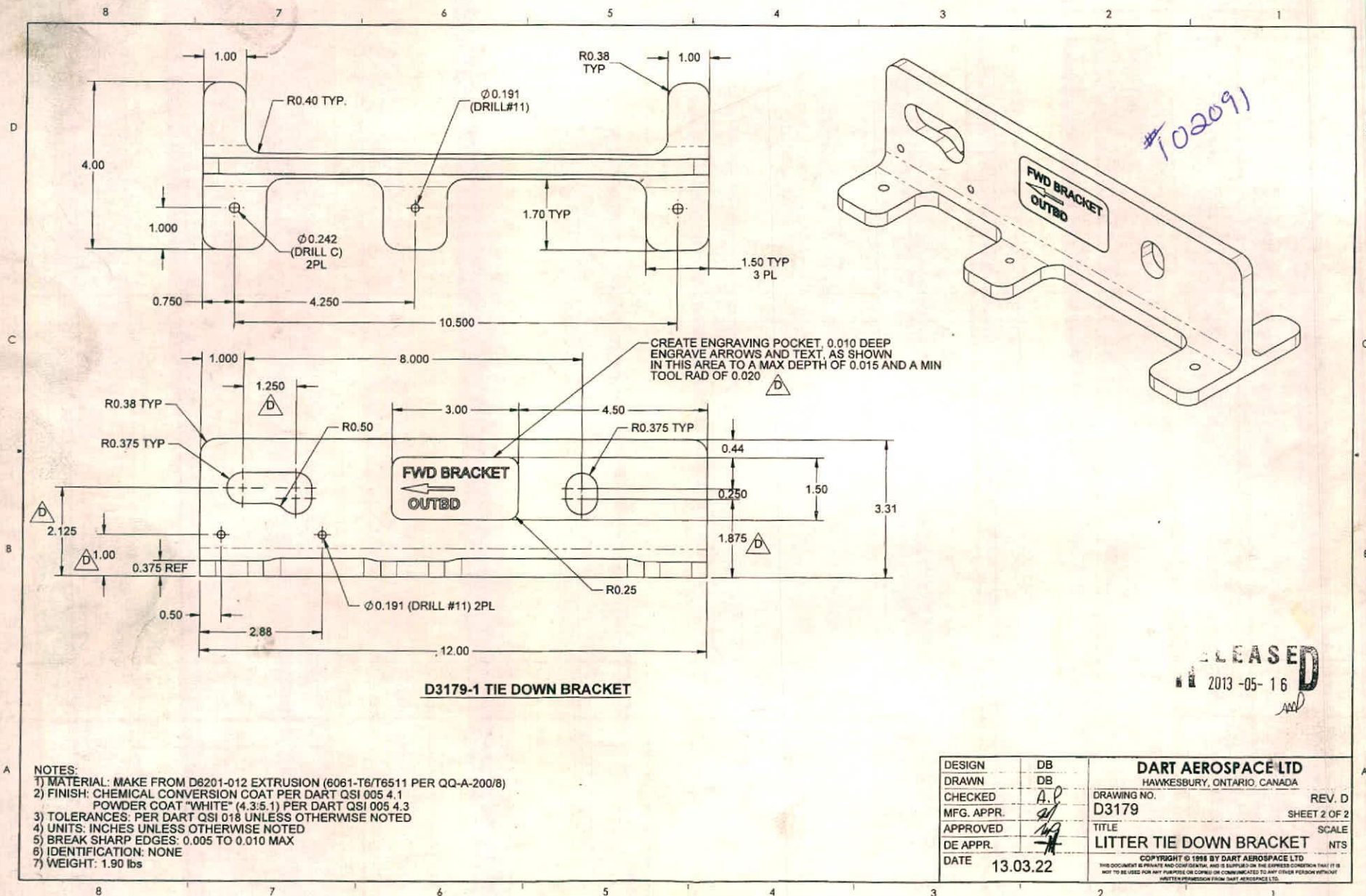
Work Order update only ☐

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WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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|--|--|---|--|

| | | | |
|--|--|---------------------|--------|
| DART AEROSPACE LTD | | Work Order: | 102091 |
| Description: Fuel lifter tie down | | Part Number: | 3179-1 |
| Inspection Dwg: D3179 Rev: 0 | | Page 1 of 12 | |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 1.00 | +/- .030 | 1.001 | ✓ | | vern | RT-4 |
| Ø .191 | + .005/- .001 | .193 | ✓ | | | |
| 1.00 | +/- .030 | .997 | ✓ | | | |
| 1.50 | +/- .030 | 1.499 | ✓ | | | |
| 1.70 | +/- .030 | 1.699 | ✓ | | depth gauge | RT-6 |
| 10.500 | +/- .010 | 10.500 | ✓ | | tape | RT-10 |
| 4.250 | +/- .010 | 4.250 | ✓ | | | |
| .750 | +/- .010 | .749 | ✓ | | | |
| 1.000 | +/- .010 | 1.000 | ✓ | | | |
| 4.000 | +/- .030 | 3.998 | ✓ | | | |
| 1.000 | +/- .010 | .999 | ✓ | | | |
| 8.000 | +/- .010 | 8.000 | ✓ | | | |
| → 3.00 | +/- .030 | 2.990 | ✓ | | | |
| → 4.50 | +/- .030 | 4.52 | ✓ | | | |
| R.375 | | .3725 | ✓ | | | |
| .44 | +/- .030 | .456 | ✓ | | | |
| 1.50 | +/- .030 | 1.470 | ✓ | | | |
| .250 | +/- .010 | .244 | ✓ | | | |
| 3.31 | +/- .030 | 3.315 | ✓ | | | |
| 1.875 | +/- .010 | 1.868 | ✓ | | | |
| 12.00 | +/- .030 | 12.000 | ✓ | | | |
| Ø.242 | + .005/- .001 | .244 | ✓ | | | |
| 2.88 | +/- .030 | 2.873 | ✓ | | | |

| | | |
|---------------------------|--------------------------------|------------------------------|
| Measured by: RT 02 | Audited by: DAG 04 9-83 | Preliminary Approval: |
| Date: 13-05-31 | Date: 13.C.3 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| E | 10.04.14 | Added preliminary approval | KJ | |

2185

10.04.15

